



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Order 11943

D3296-1
Job Sheet 188888

Part No: D3296-1

Job Qty: 10 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	2/12/19	2/12/19	0.03	1.04	Waterjet - Flow		SC 1/29/19
120	QC	10 pcs	2/12/19	2/12/19	0.00	0.00	QC8		38
140	HandFinish	10 pcs	2/12/19	2/12/19	0.00	0.53	HandFinish1		DR 1/22/19
150	QC	10 pcs	2/12/19	2/12/19	0.00	0.00	QC7-2		DAS FEB 12 2019 68
160	Packaging	10 pcs	2/12/19	2/12/19	0.00	0.00	Packaging3		DAS 6 9-89
170	QC21-SA	10 Ea	2/12/19	2/12/19	0.00	0.00	QC21		21 9-89 FEB 14 2019 FEB 13 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	6.5960 sf (.6596 ea)	100-Waterjet - Flow - 1	5146235

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	7	6	0



Container No: S148724



Part: D3296-1

Job No: 188888

Serial No/Batch: S148724

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/29/19

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.080inches $\pm$ 0.030	5.110 5.050	5,082	
2	Door Panel	0.060inches $\pm$ 0.030	0.090 0.030	0,060	
3	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0,303	
4	Door Panel	0.128inches $\pm$ 0.005 - 0.000	0.133 0.128	0,129	
5	Door Panel	16.400inches $\pm$ 0.005	16.405 16.395	16,403	
6	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0,301	
7	Door Panel	13.400inches $\pm$ 0.005 - 0.030	13.405 13.370	13,402	
8	Door Panel	17.000inches $\pm$ 0.030	17.030 16.970	17,004	
9	Door Panel	14.180inches $\pm$ 0.030	14.210 14.150	14,186	
10	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0,302	
11	Door Panel	0.063inches $\pm$ 0.010	0.073 0.053	0,061	

Plex 1/16/19 11:43 AM Dart.Macdonald.Dara

DAS
9662019
FEB 13 2019

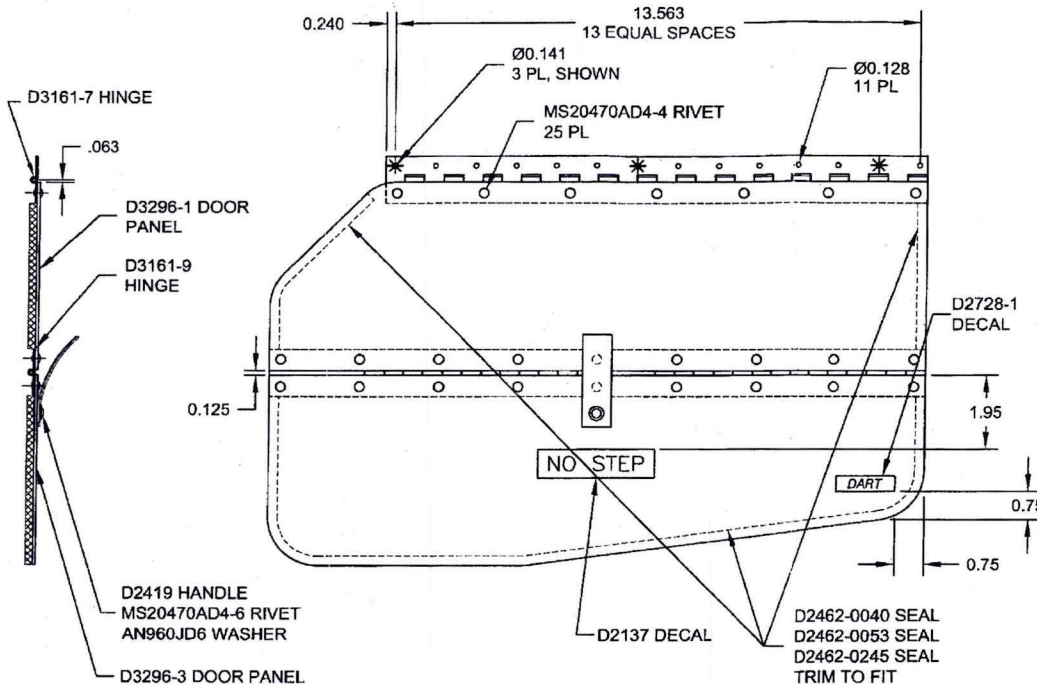
8 7 6 5 4 3 2 1

D

C

B

A



D3296-041 DOOR ASSEMBLY

D3296-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

QTY	PART NUMBER	DESCRIPTION
X	D3296-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

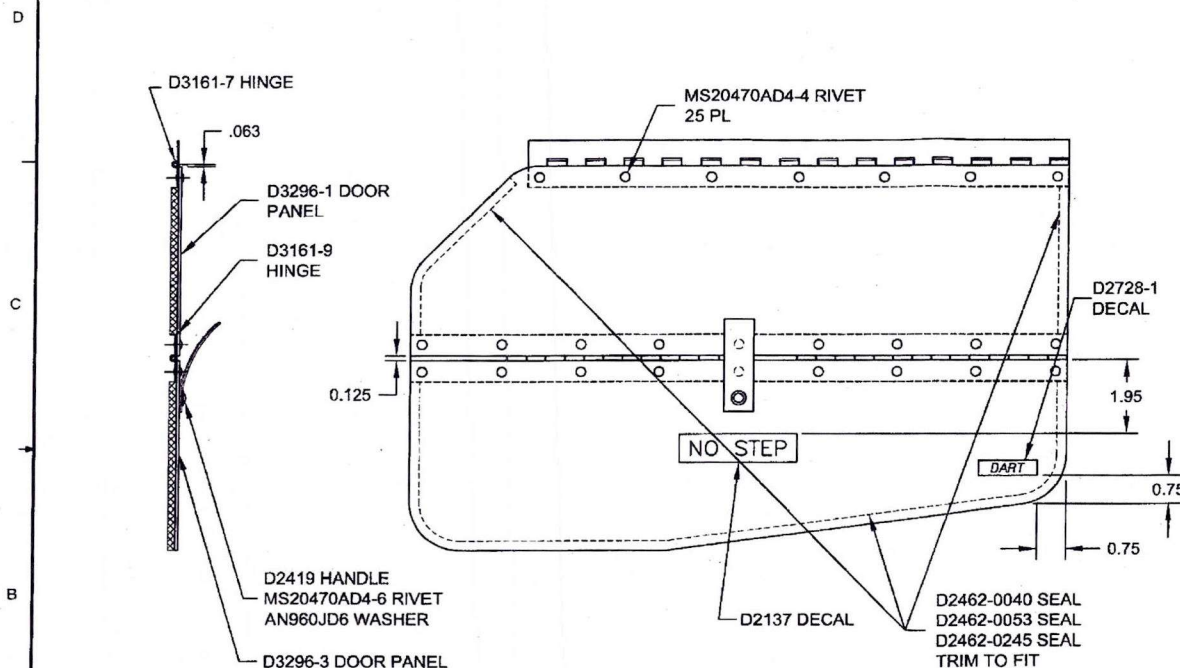
RELEASED
2012-11-21

B	ADD D3296-041B. REF. PART2-223.		MB	12.11.15
A	NEW ISSUE		CP	04.06.28
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		DRAWING NO. D3296	REV. B SHEET 1 OF 3	
DATE	12.11.15	TITLE DOOR ASSEMBLY	SCALE NTS	
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

QTY -041B	PART NUMBER	DESCRIPTION
X	D3296-041B	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET



D3296-041B DOOR ASSEMBLY, BLANK

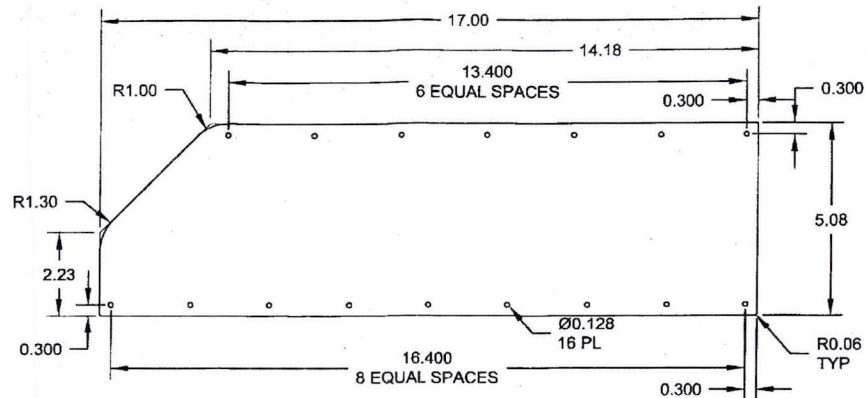
D3296-041B NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
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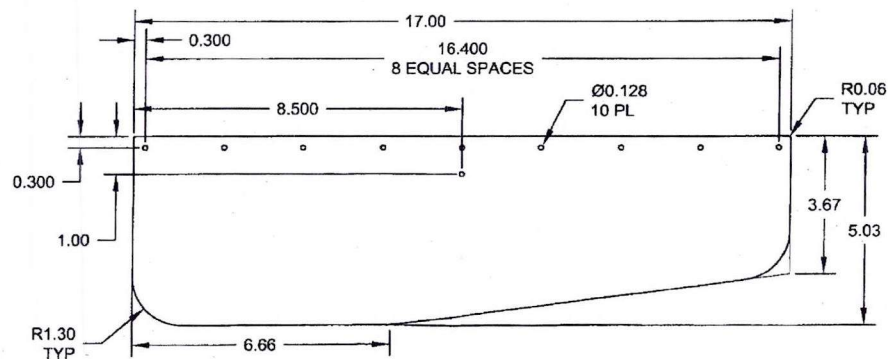
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2012-11-21
WNO

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CHECKED		DRAWING NO. D3296	REV. B
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		DOOR ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1/3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3296-1 = 0.52 lbs; D3296-3 = 0.50 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3296	SHEET 3 OF 3
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RELEASED
2012-11-21
WFO

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			